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K6A 1K7
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D117-762-041
Job Sheet 200705



Part No: D117-762-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/17/19

Job Tracking No:

Due Date: 10/18/19

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: DWG D3582 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA as per dwg DD verF by:EC IPP REV:C 15.06.11 AS PER CHG002 DD VERF:JLM IPP REV:D 16.02.05 DWG REV:C (ecn16-514) DD VERF:JLM IPP REV:E 17.01.17 as per dwg REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	Skidtubes - 1	1 pcs	10/18/19		0.00	3.30	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
140	Skidtubes - 2 - B4B	1 pcs	10/18/19		0.00	3.30	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
150	QC 10	1 pcs	10/18/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
160	QC 5	1 pcs	10/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		

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				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	OCT 10 2019 ^{DAS} 68
				QC 5 - 9	3-59
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	10/18/19	0.00 0.97	Handfinish - 1 - 1 - B4B	BFB19-10-10
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	

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180 QC 7	1 pcs	10/18/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 79	00 DAS 79 9-89
190 Skidtubes - 3 - B4B	1 pcs	10/18/19 00	0.00 3.33 2.38 2.61 2h	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 10	1 pcs	10/18/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
210 QC 5	1 pcs	10/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	

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						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	DAS
						QC 5 - 68	OCT 21 2019 68
						QC 5 - 9	9-89
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
215 Handfinish - 2-1 Pressure-B4B	1 pcs	10/18/19	0.00 0.97		Handfinish - 2 - 1 - B4B	BEB 19-10-21	
					Handfinish - 2 - 2 - B4B	1	
					Handfinish - 2 - 3 - B4B		
					Handfinish - 2 - 4 - B4B		
220 Powdercoat - 1 White Gl(A)-B4B	1 pcs	10/18/19	0.00 0.26		Powdercoat - 1 - B4B		
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B	BR 14-10-22	
					Powdercoat - 4 - B4B		
230 QC 3	1 pcs	10/18/19	0.00 0.00		QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15		
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59	BEB 19-10-22	
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40		
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
250 Handfinish - 4-1-Assembly-B4B	1 pcs	10/18/19	0.00 0.97		Handfinish - 4 - 1 - B4B		
					Handfinish - 4 - 10 - B4B	BEB 19-10-22	
					Handfinish - 4 - 11 - B4B		
					Handfinish - 4 - 12 - B4B		
					Handfinish - 4 - 13 - B4B		
					Handfinish - 4 - 14 -		

					B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	10/18/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
270 Packaging 3-1 - Stock - B4B	1 pcs	10/18/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
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					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	

OCT 23 2019 40 9-89

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	78 OCT 23 2019
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
275 DC - 1 - B4B	1	10/18/19	0.00 0.00	DC - 1 - B4B	21 OCT 23 2019
	pcs			DC - 2 - B4B	9-89
280 QC 21 - FG	1	10/18/19	0.00 0.00	QC 21 - FG - 21	DAS
	pcs			QC 21 - FG - 70	21
				QC 21 - SA - 53	9-39 OCT 23 2019

Part Op 130 - Skidtubes-1 (Skidtubes) 1-Cut Aft end using DT8185 2-Deburr ends 3-Drill Aft Cap holes using DT8678 *** OPEN
 Descriptions: AFT CAP HOLE TO .187" *** 4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube. 5-Install 3/16
 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill. 6-Drill pilot holes for wearplates using DT8900 7-
 Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582. 8-Drill holes for D5520-1 doubler using DT10309 A & B,
 locating from 4th and 5th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove
 DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleko as you go. Remove .1875
 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 9-Deburr doubler and
 doubler holes in skid tube. 10-Countersink doubler holes in skid tube as per Dwg. detail J and note 12 -Touch up alodine
 on D5520-1 doublers. 11- open ground wear holes to 0.391" as per section B-B 12-Open Aft Cap holes using .209" drill.
 13-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65
 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size. 12-Do not open
 holes of section G-G to finishes size.

140 - Skidtubes-1 (Skidtubes) 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD

Batch: 138989 1139011 2-Grind flush

150 - QC10 (QC10- Inspect visual per QSI004- ground welds)

160 - QC5 (QC5- Inspect part completeness to step on W/O)

170 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

180 - QC7-1 (QC7-Inspect Chemical Conversion Coat)

190 - Skidtubes-1 (Skidtubes) ***MASK OFF HOLES OF SECTION F-F (DO NOT C'SINK) 1-Open X-Bolt holes to finish
 size as per Dwg D3582, sections D-D, E-E, G-G as per Dwg. 2-Counter Sink X-BOLT holes as per Dwg D3582 D-D, E-E
 and G-G.***Do NOT countersink holes of section F-F). 3-Deburr and blow out chips from inside of tube, prep. tube for
 welding. 4-Install doublers using DT10309 B. Shave rivets as required. 5-Bond web as per Dwg D3582 & QSI 015 A/R
 241 Sika Flex Batch: 520925 Exp Date: 07/25/2020 6- Swage x-bolt spacer as per dwg and
 Section F-F QSI002. 7-Weld x-bolt spacers as per Dwg D3582 section D-D, E-E and G-G. A/R AL ROD

Batch: 138989 8-Grind welds flush

200 - QC10 (QC10- Inspect visual per QSI004- ground welds)

210 - (QC5- Inspect part completeness to step on W/O)

215 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch-up alodine as per QSI

220 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME _____ OVEN TEMPERATURE:
 FINISH TIME: _____

230 - (QC3- Inspect Part Finish)

250 - HandFinish4 (Assemble as per dwg) 1-Inspect for Foreign objects 2-Install Aft cap as per Dwg D3582, Detail "C"
 A/R 241 Sika Flex Batch: 5200625 Exp Date: 20/07 3-Install Wearplates as per Dwg D3582 ,
 Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install
 bolts where indicated on Dwg(Note #6)***** 4- Wing Walk as per Dwg D3582 and QSI 005 4.4

260 - (QC5- Inspect part completeness to step on W/O)

270 - Identify and pack for shipping as per PPP D117-762-041 Location :FG081

wing walk 5209362

275 - (Document Control) Photocopy bluefile & type labels per PPP D117-762-041 CHG003

280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3582-1-BENT	Skidtube Assembly BK117	1 pcs (1 ea)	130-Skidtubes - 1	520825
D5520-1	Doubler	2 pcs (2 ea)	130-Skidtubes - 1	5218923
D2964	Cap	1 pcs (1 ea)	140-Skidtubes - 2 - B4B	5146305
CR3212-5-05	Rivet	68 pcs (68 ea)	190-Skidtubes - 3 - B4B	5244685
D2971	Cross Bolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5097024
D3584-1	Web	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5174779
D3662-1	Crossbolt Spacer	3 pcs (3 ea)	190-Skidtubes - 3 - B4B	5173644
D3662-3	Crossbolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5181606
D5304-1	Crossbolt Spacer	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	51827
ALS4-1032-130	Rivnut	36 Ea (36 ea)	250-Handfinish - 4-1-Assembly-B4B	5057257
ALS4-428-165	Insert	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5147561
AN3-5A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5216385
AN3C4A	Bolt	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	5218780
AN4-4A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5193116
D2965	Cap	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5166520
D3508-11	Wearplate Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5192981
D3508-13	Wearplate Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172983
D3508-3	Wearplate Fwd Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172576
D3508-9	Wearplate Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172977
D3558-11	Gasket Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210680
D3558-13	Gasket Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210686
D3558-3	Gasket Center Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210684
D3558-9	Gasket Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210682
NAS1149C0332R	Washer (AN960C10L)	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	5218154
NAS1149D0332J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5178378
NAS1149D0416J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	51131511

M.A. 612547

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
130-Skidtubes - 1	D3582-1-BENT	1	5	0
	D5520-1	2	4	0
140-Skidtubes - 2 - B4B	D2964	1	24	0
	CR3212-5-05	68	282	0
190-Skidtubes - 3 - B4B	D2971	1	64	0
	D3584-1	1	6	0
250-Handfinish - 4-1-Assembly-B4B	D3662-1	3	22	0
	D3662-3	1	37	0
	D5304-1	2	10	0
	ALS4-1032-130	36	6,008	0
	ALS4-428-165	2	72	0
	AN3-5A	2	38	0
	AN3C4A	28	584	0
	AN4-4A	2	50	0
	D2965	1	52	0
	D3508-11	1	13	0
	D3508-13	1	9	0
	D3508-3	1	16	0
	D3508-9	1	14	0
	D3558-11	1	13	0
	D3558-13	1	5	0
	D3558-3	1	14	0
	D3558-9	1	14	0
	NAS1149C0332R	28	3,016	0
	NAS1149D0332J	2	1,896	0
	NAS1149D0416J	2	1,779	0

Part Specifications	
Specifications could not be found.	

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ITEM	Qty	Part Number	Description
	X	D3612-041	SKIDTUBE ASSEMBLY
1	1	D2602-160	EXTRUSION
2	1	D2664	CAP
3	1	D2665	CAP
4	1	D2671	CROSS BOLT SPACER
5	1	D3508-3	WEARPLATE
6	1	D3508-8	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3508-3	GASKET
10	1	D3558-9	GASKET
11	1	D3558-11	GASKET
12	1	D3558-13	GASKET
13	1	D3664-1	WEB
14	3	D3662-1	CROSS BOLT SPACER
15	1	D3662-3	CROSS BOLT SPACER
16	2	D3504-1	CROSS BOLT SPACER
17	2	D5520-1	DOUBLER
18	28	AN3CA4	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-4A	BOLT
21	28	NAS1149C0332R	WASHER (AN860C10L)
22	2	NAS1149D0332J	WASHER (AN860JD10L)
23	2	NAS1149D0416J	WASHER (AN860JD416L)
24	38	AE1S-1032-130	INSERT
25	2	AL37-42B-165	INSERT
26	68	CR3212-5-05	CSK RIVET, CHERRY MAX

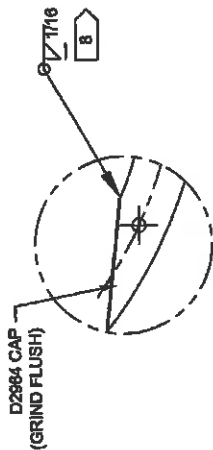
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 200705

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 PRIOR TO INSERTING D3664-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 18.2 lbs
 - 8) WELDING: PER DART QSI 004.
 - 9) INSERT D3664-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-2411-281 ADHESIVE PER DART QSI 016 AFTER BENDING.
 - 10) USE DART DRILL TEMPLATE DT18900 TO LOCATE AND DRILL Ø0.287 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH SEAL WEARPLATE BOLTS WITH SIKAFLEX-2411-281.
 - 11) DO NOT INSTALL AN3CA4 BOLTS AND NAS1149C0332R WASHERS IN INDICATED LOCATIONS
 - 12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.181 THRU SKIDTUBE AND DOUBLER USING DT10308. COUNTERSINK Ø0.286 x 100° (34 PL) PER DOUBLER AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS.

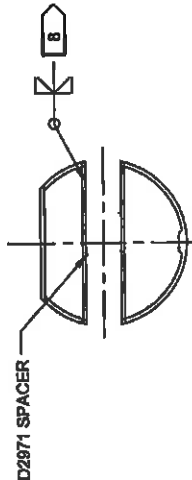
RELEASED
2017-08-11
EW 17-547

E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 26 AND NOTE 12-13. Ø0.181 HOLE WAS Ø0.176. ADD SHT 3. ADD DETAIL J. SECTION F-F ADD D5520-1. SCALE ON VIEWS WAS 3X.	AJS	17.03.27
D	D5504-1 WAS D2673; REVISE BOM & SECTION F-F & SECTION NOTES (ZN B7-3, A8-3); REF NCR16-8100	RF	17.01.09
C	D3482 PLUG ASSEMBLIES REMOVED. REFORMAT NOTES SHT 1	AP	15.11.02
B	29.88 WAS 28.87 (ZN C2-1). INCORPORATED DEO D5582-A-1 (ZN D5-1). FORMAT TO CURRENT STD	RF	15.02.20
A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	AJS		
CHECKED	MAK		
MFG. APPR.	DU	D3582	DRAWING NO.
APPROVED			REV. E
DATE	17.03.27		SHEET 1 OF 4
			SCALE
			NTS
			SKIDTUBE ASSEMBLY
			CONFIDENTIAL © 2007 BY DART AEROSPACE USA, INC.
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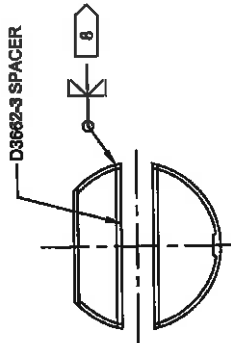
DART AEROSPACE USA, INC.
EUGENE, OR



DETAIL C
SCALE 4X



SECTION D-D
SCALE 4X



SECTION E-E
SCALE 4X

SECTION D-D NOTES

AFTER BENDING AND DRILLING ASSEMBLY

PERFORM THE FOLLOWING:

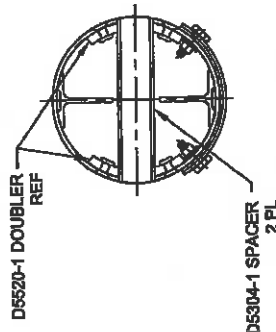
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2871 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER

SECTION E-E NOTES

AFTER BENDING AND DRILLING ASSEMBLY

PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-3 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.872 DRILL TO REMOVE SPILL OVER



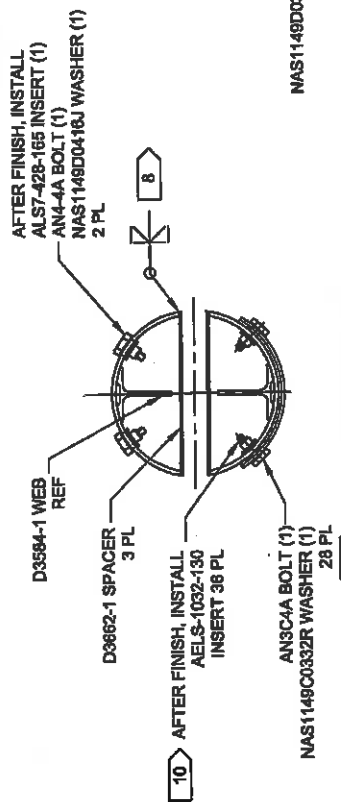
SECTION F-F
SCALE 4X

SECTION F-F NOTES

AFTER BENDING AND DRILLING ASSY

PERFORM THE FOLLOWING:

1. INSERT D5304-1 SPACER
2. SWAGE TO Ø0.585 +0.005/-0.000 X 1.0
3. DEEP PER QSI 002
4. OPEN THRU HOLE TO Ø0.625



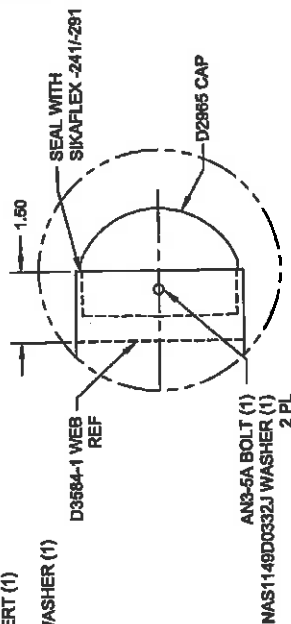
SECTION G-G
SCALE 4X

SECTION G-G NOTES

AFTER BENDING AND DRILLING ASSEMBLY

PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-1 SPACER (3 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER



DETAIL H
SCALE 4X

DESIGN	PH	REV. E
DRAWN	AJS	EUGENE, OR
CHECKED		DRAWING NO.
MFG. APPR.		D3582
APPROVED		TITLE
DE APPR.		BK 117 SKIDTUBE ASSEMBLY
DATE	17.03.27	SCALE
		SHEET 3 OF 4

RELEASED
N 2017-08-11

DART AEROSPACE USA, INC
EUGENE, OR
SHEET 3 OF 4
TITLE
BK 117 SKIDTUBE ASSEMBLY
SCALE
DATE 17.03.27

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____		DISPOSITION		DEPARTMENT/PROCESS			
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube Machining ☐ Large Fab ☐		Cross tube Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)			
Description Work Order Deviation		Disposition		Completed By			
				Lead hand / Supervisor			
Root Cause		FAULT CATEGORY		QC / QA Coordinator			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Other/Details: _____							